

Work Order ID 75093

75093

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October-17-11 1:22:33 PM

Item ID: D3574-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 17/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

B11-10-18

(4)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B11-10-18

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

8/11/19

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

Signature 11/10/2011

Signature

Signature

Signature

Dart Aerospace Ltd

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Revision ID:

Item Name: Cabin Floor Protector

Stop ***NS2***

Start Date: 17/10/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

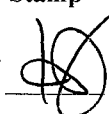
160

QC

Memo

0.00

Quality Control

11/10/24 mf
11-10-21

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Picklist Print

October-17-11 1:22:37 PM

Page 1

Work Order ID: 75093

75093

Parent Item: D3574-1

D3574-1

Parent Item Name: Cabin Floor Protector

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

sf

886.1763

134.4672

MI FXS 125-F60029-04

**

B11-10-18

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

886.176289

116236

886.176289

116236

(4)

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	75093
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.002	✓		VIBOZ	
7.37	+/-0.030	7.37	✓		T, B61	
10.75	+/-0.030	10.75	✓		T	
11.00	+/-0.030	11.00	✓		T	
15.25	+/-0.030	15.25	✓		T	
25.87	+/-0.030	25.87	✓		T	
39.75	+/-0.030	39.75	✓		T	
44.75	+/-0.030	44.75	✓		T	
49.11	+/-0.030	49.11	✓		T	
51.11	+/-0.030	51.11	✓		T	
53.51	+/-0.030	53.51	✓		T	
63.50	+/-0.030	63.50	✓		T	
65.25	+/-0.030	65.25	✓		T	
10.75	+/-0.030	10.75	✓		T	
11.06	+/-0.030	11.06	✓		T	
14.75	+/-0.030	14.75	✓		T	
25.50	+/-0.030	25.50	✓		T	
25.75	+/-0.030	25.75	✓		T	
26.00	+/-0.030	26.00	✓		T	
32.87	+/-0.030	32.87	✓		T	
38.81	+/-0.030	38.81	✓		T	
44.75	+/-0.030	44.75	✓		T	
45.00	+/-0.030	45.00	✓		T	
48.25	+/-0.030	48.25	✓		T	
58.38	+/-0.030	58.38	✓		T	
61.25	+/-0.030	61.25	✓		T	
64.13	+/-0.030	64.13	✓		T	
64.63	+/-0.030	64.63	✓		T	
66.50	+/-0.030	66.50	✓		T	
7.50	+/-0.030	7.50	✓		T	
9.50	+/-0.030	9.50	✓		T	
10.38	+/-0.030	10.38	✓		T	
10.88	+/-0.030	10.88	✓		T	
14.50	+/-0.030	14.50	✓		T	

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75093
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	15.56	X		T B01	
18.75	+/-0.030	18.75	X		T	
24.13	+/-0.030	24.13	X		T	
26.50	+/-0.030	26.56	X		T	
30.50	+/-0.030	30.45	X		T	
33.88	+/-0.030	33.88	X		T	
39.50	+/-0.030	39.50	X		T	
40.25	+/-0.030	40.25	X		T	
43.50	+/-0.030	43.56	X		T	
43.83	+/-0.030	43.83	X		T	
46.60	+/-0.030	46.60	X		T	
7.63	+/-0.030	7.63	X		T	
11.00	+/-0.030	11.06	X		T	
11.50	+/-0.030	11.50	X		T	
16.75	+/-0.030	16.75	X		T	
19.00	+/-0.030	19.06	X		T	
22.50	+/-0.030	22.50	X		T	
30.75	+/-0.030	30.75	X		T	
32.63	+/-0.030	32.63	X		T	
32.75	+/-0.030	32.75	X		T	
35.13	+/-0.030	35.13	X		T	
36.50	+/-0.030	36.56	X		T	
40.00	+/-0.030	40.00	X		T	
41.88	+/-0.030	41.88	X		T	
43.63	+/-0.030	43.63	X		T	
0.125	+/-0.010	.130	X		V B02	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-10-18	Date: 11/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

Dart Aerospace Ltd

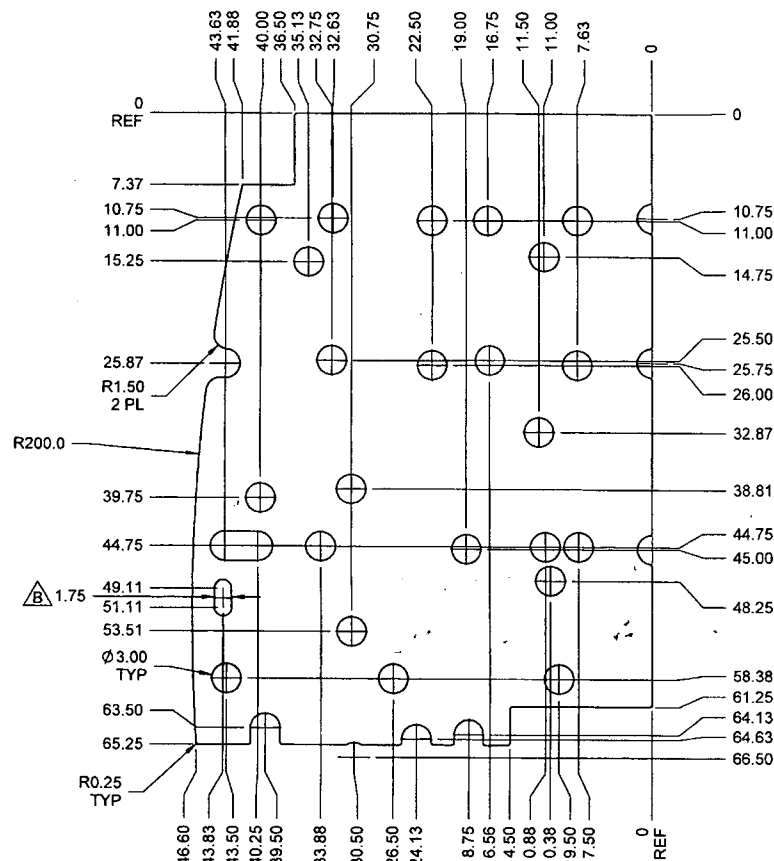
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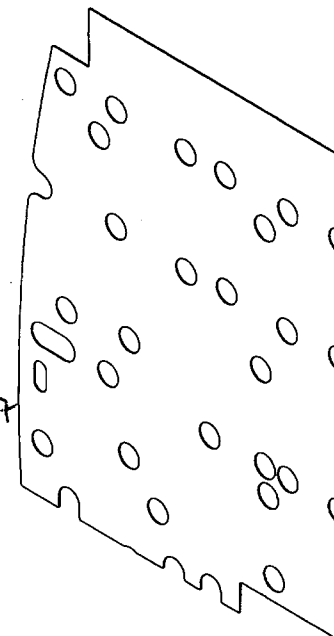
D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75093

M.L.J
11/10/17



RELEASED
09/04/07

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3574** REV. B
SHEET 1 OF 6
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

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Dart Aerospace Ltd

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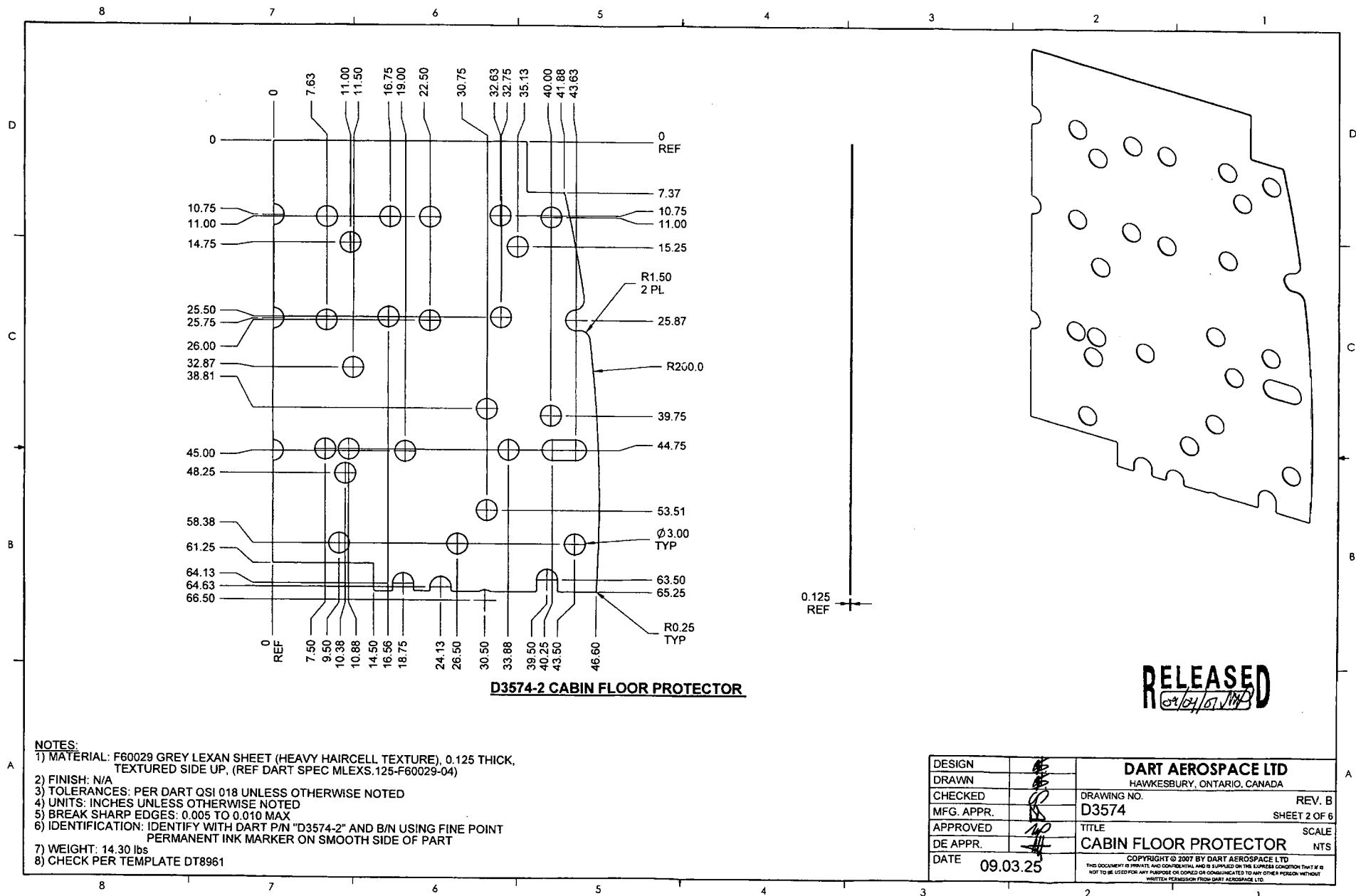
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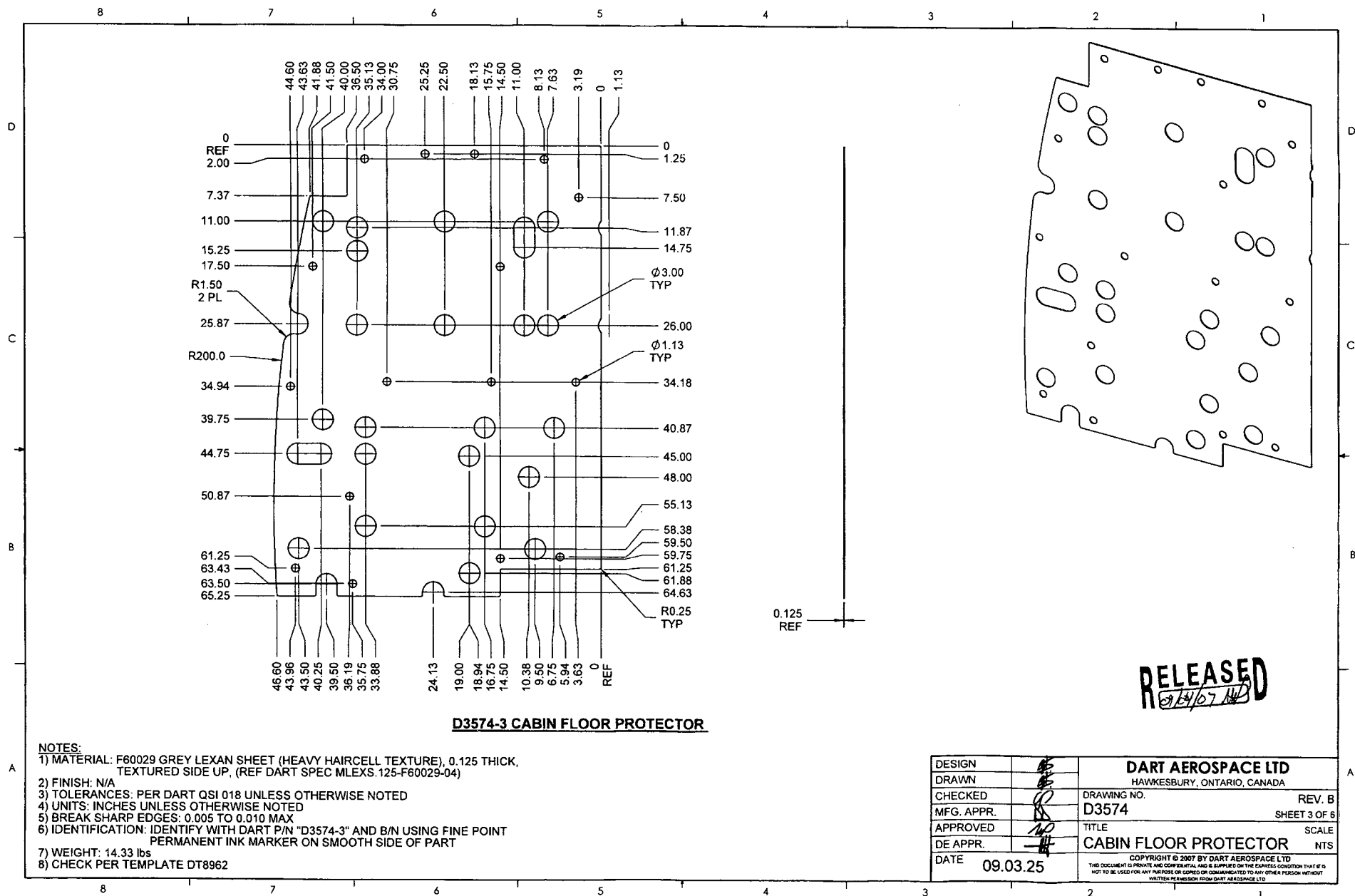
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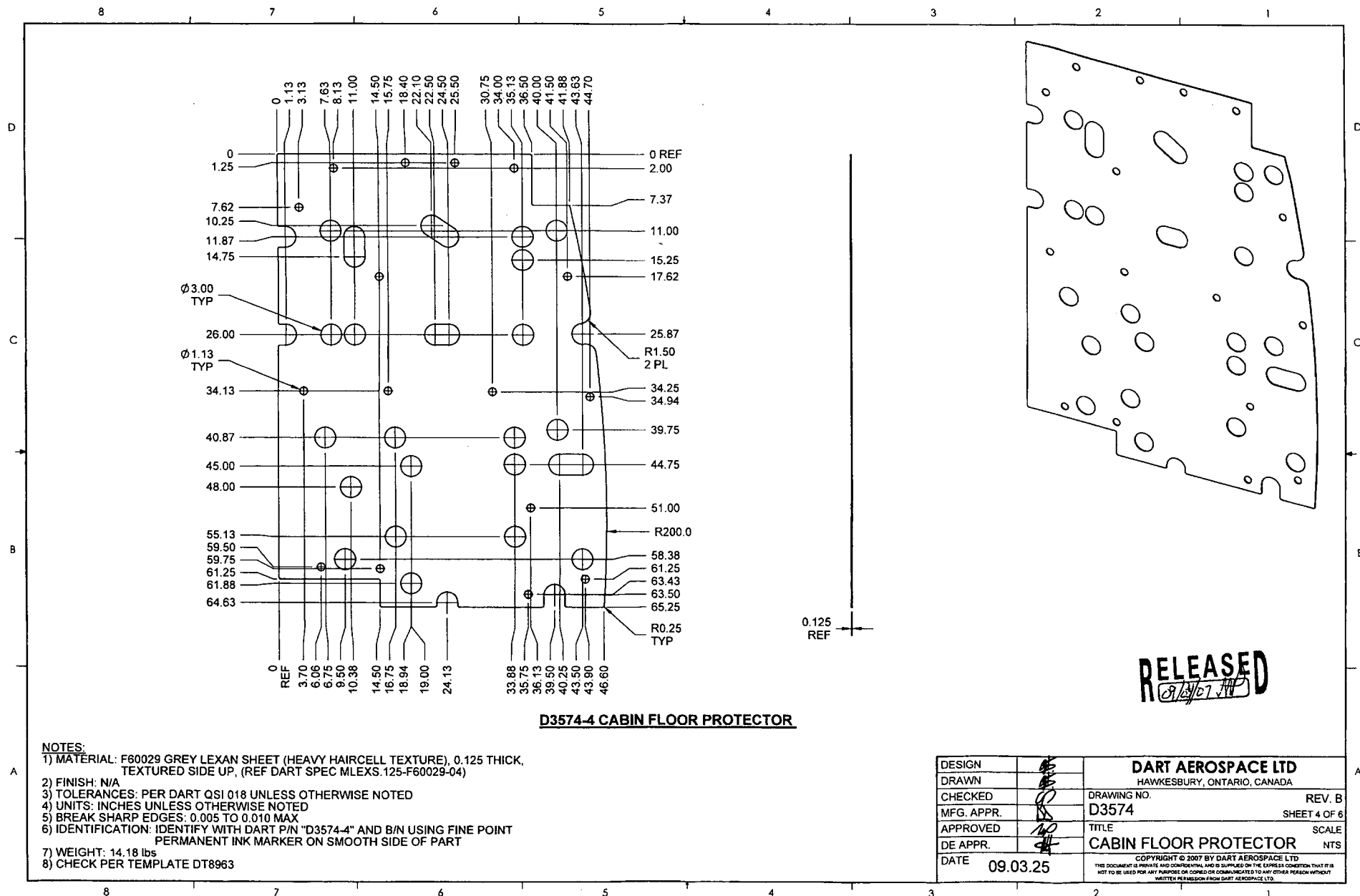
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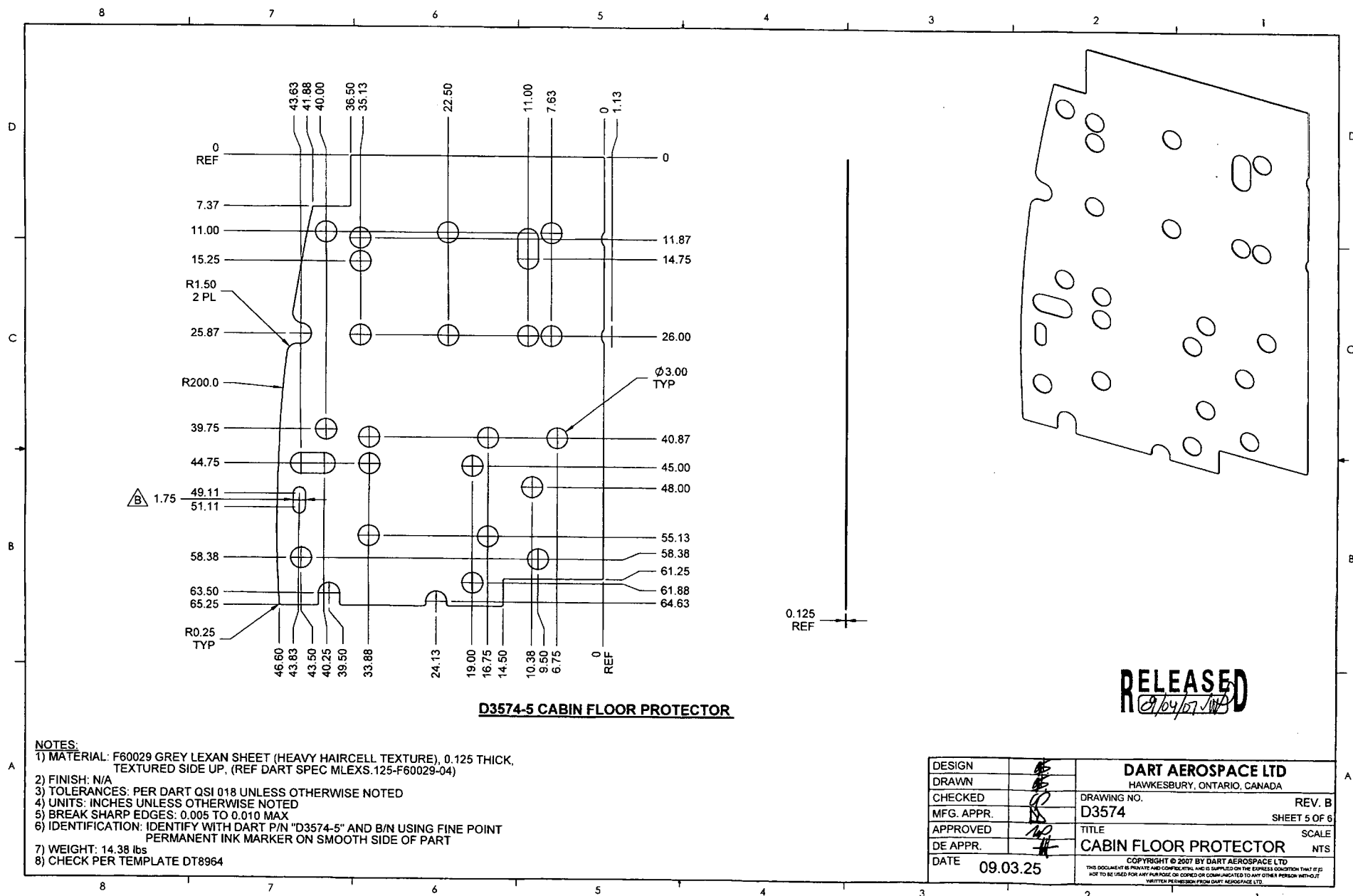
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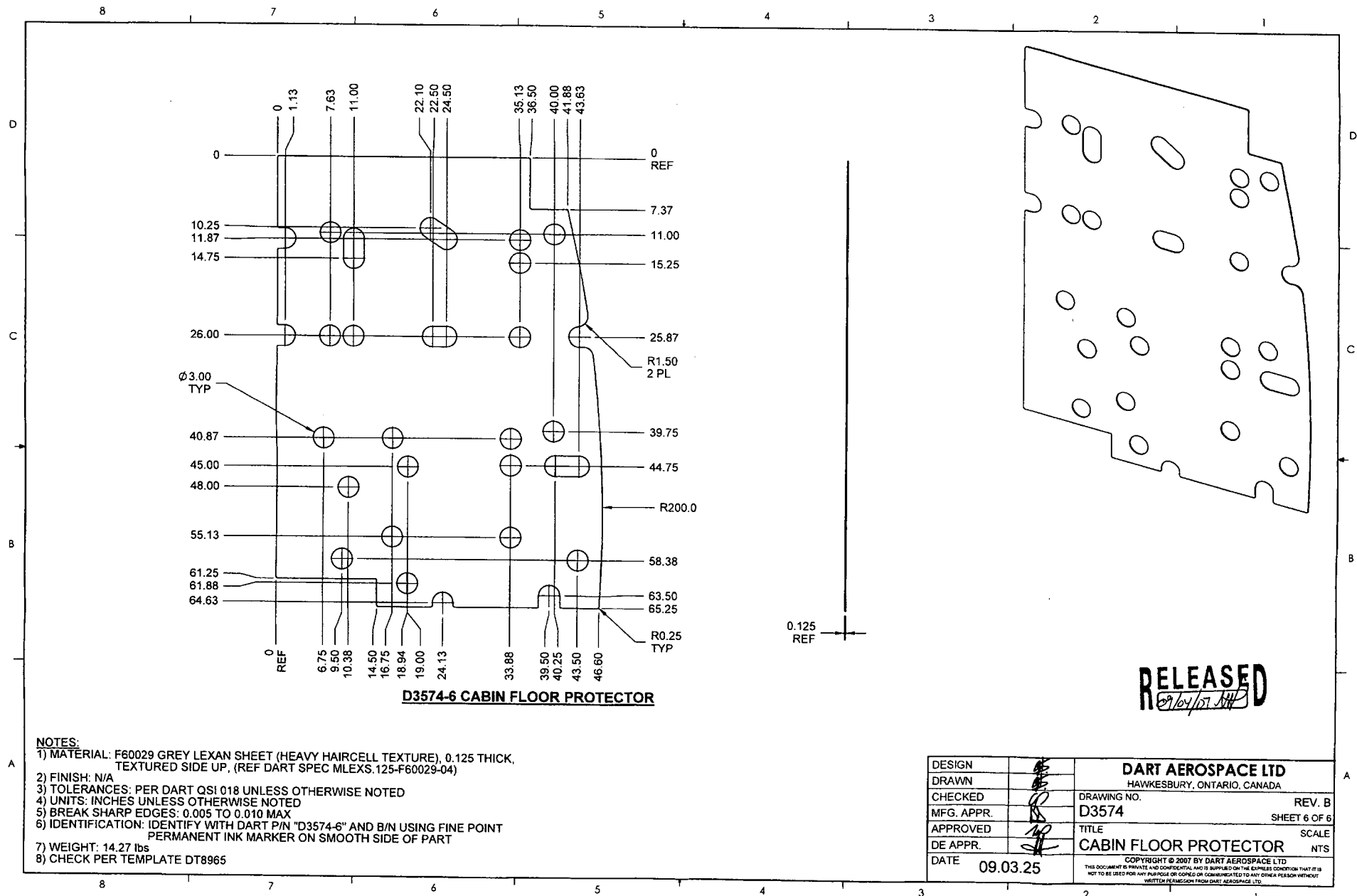
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RELEASED
09/04/07 JHP

Dart Aerospace Ltd

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